

Date: Wednesday, 11/21/2007 12:51:43 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	CABIN FLOOR PROTECTOR
Job Number	35948			
Estimate Number	12970			
P.O. Number	N/A		Part Number	D35746
This Issue	11/21/2007	S.O. No. N/A	Drawing Number	D3574 REV.A
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	A
Previous Run	35090		Material	N/A
Written By			Due Date	11/28/2007
Checked & Approved By			Qty:	4
Comment	Est Rev: A	New Issue 07.07.23	Um:	Each
		EC	verified by:	JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	F60029	lexan grey
	Comment: Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s) F60029 lexan sheet Batch: 105330 HB 07-11-22	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: A HB 07-11-22 Prog Rev: A	
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr if necessary.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/17/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35948

Part Number: D35746

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6-21/126-4

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *7/4/26 (4)*

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11-21/127

Job Completion



11-07.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1

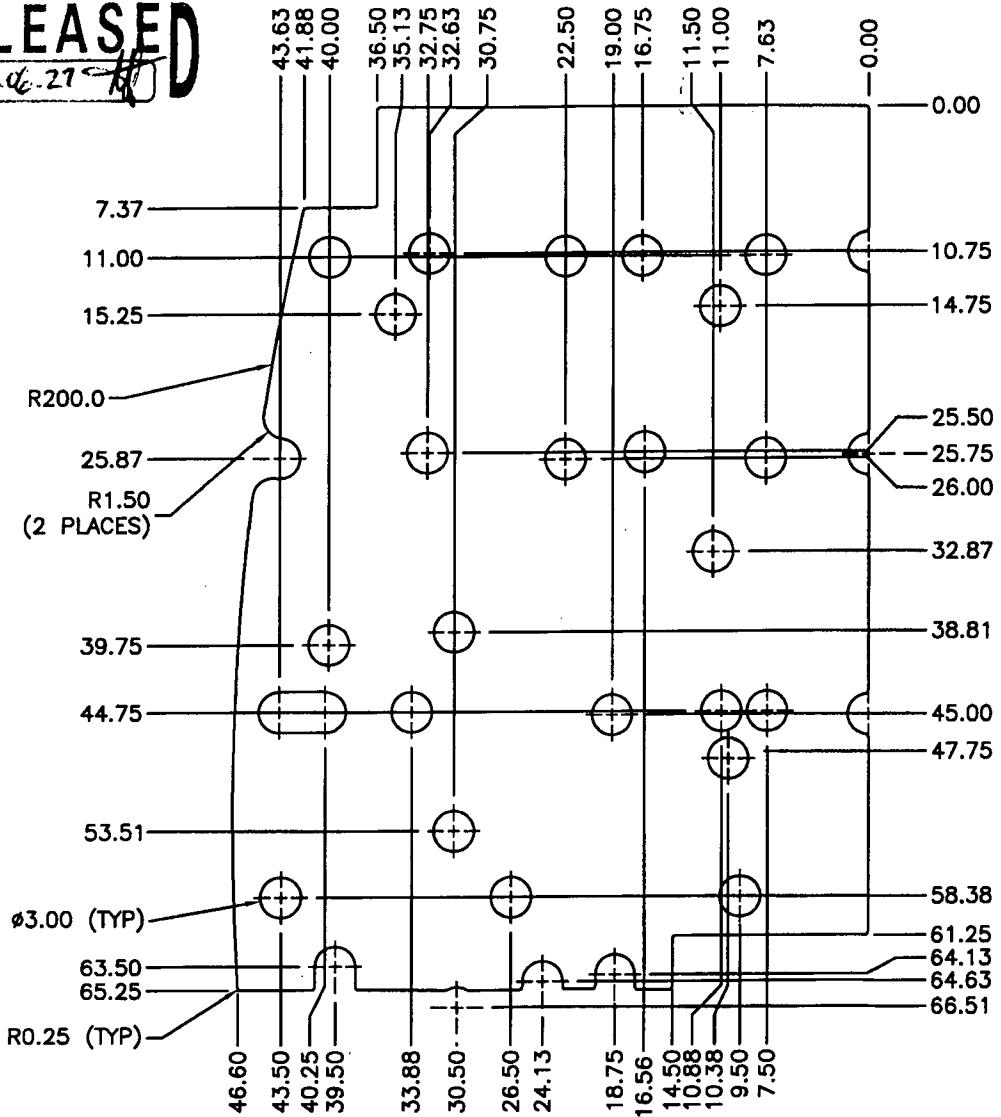
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07.06.21 *CH*

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 35948

D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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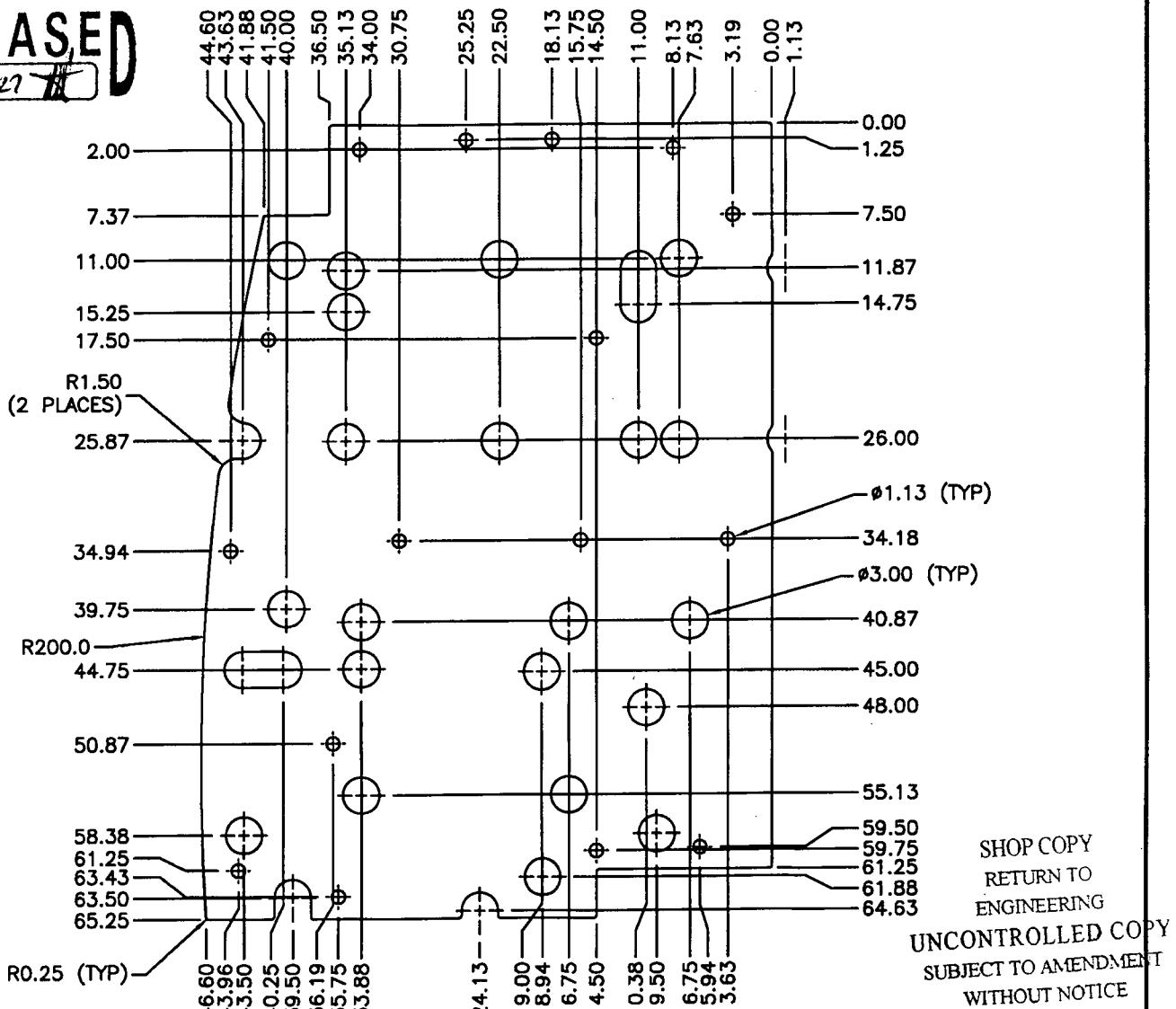
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:144	

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07.06.27

07.06.27 T



D3574-3 CABIN FLOOR PROTECTOR

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WORK ORDER
NO. 35948

NOTES:

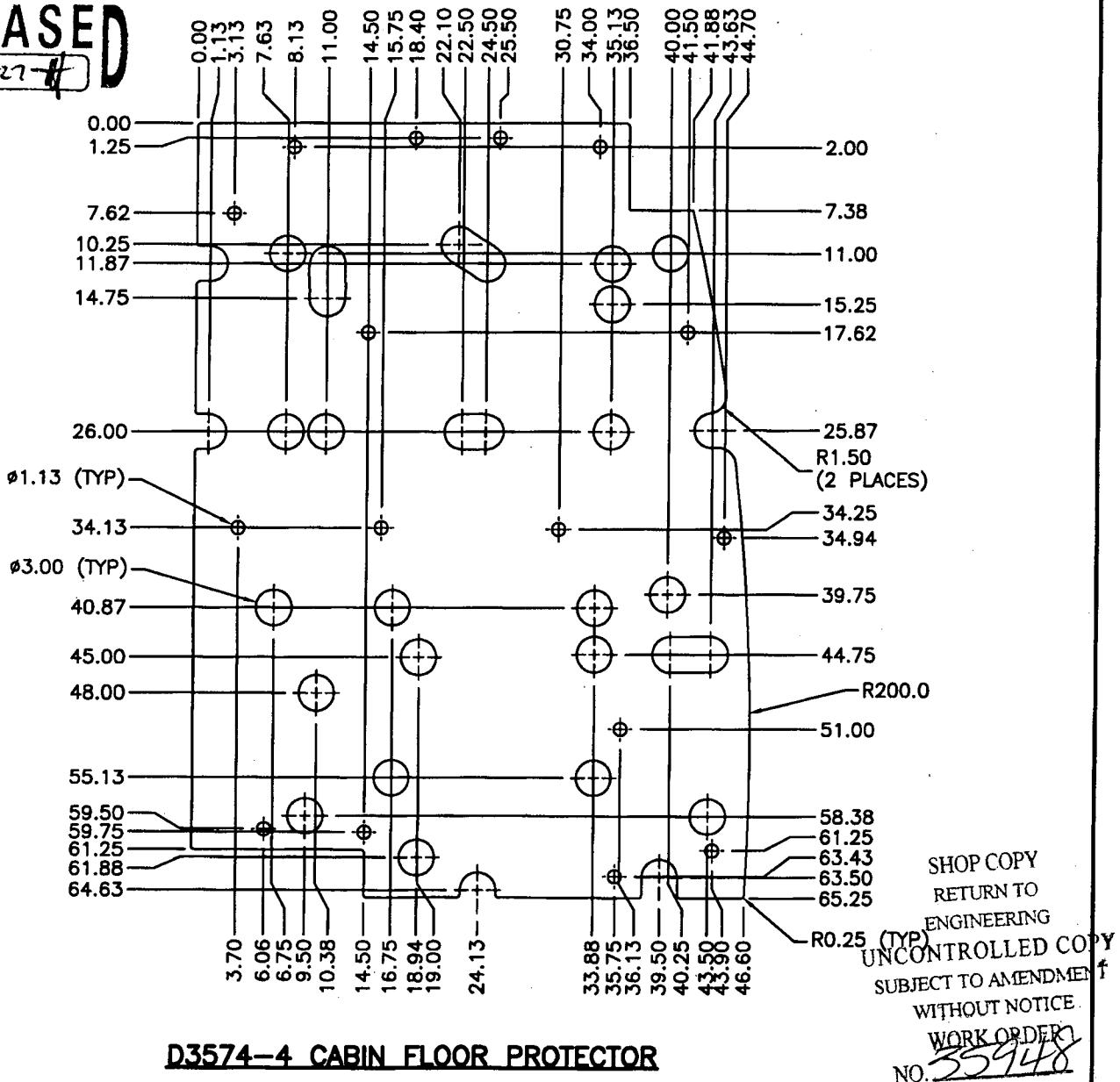
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

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CHECKED <i>CE</i>	APPROVED <i>JH</i>	DRAWING NO. D3574	REV. A SHEET 3 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27-#**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

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CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D3574	REV. A	SHEET 4 OF 5
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14	

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07-06-27 #

EASED
6.27.44

43.63
41.88
40.00
36.50
35.13
22.50
11.00
7.63
0.00
1.13
0.00
7.37
11.00
15.25
R1.50
(2 PLACES)
25.87
R200.0
39.75
40.87
44.75
45.00
48.00
55.13
61.25
61.88
64.63
63.50
65.25
58.38
46.60
43.50
40.25
39.50
33.88
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19.00
18.94
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9.50
6.75
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Ø3.00 (TYP)
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D3574-5 CABIN FLOOR PROTECTOR

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WORK ORDER
NO. 35948

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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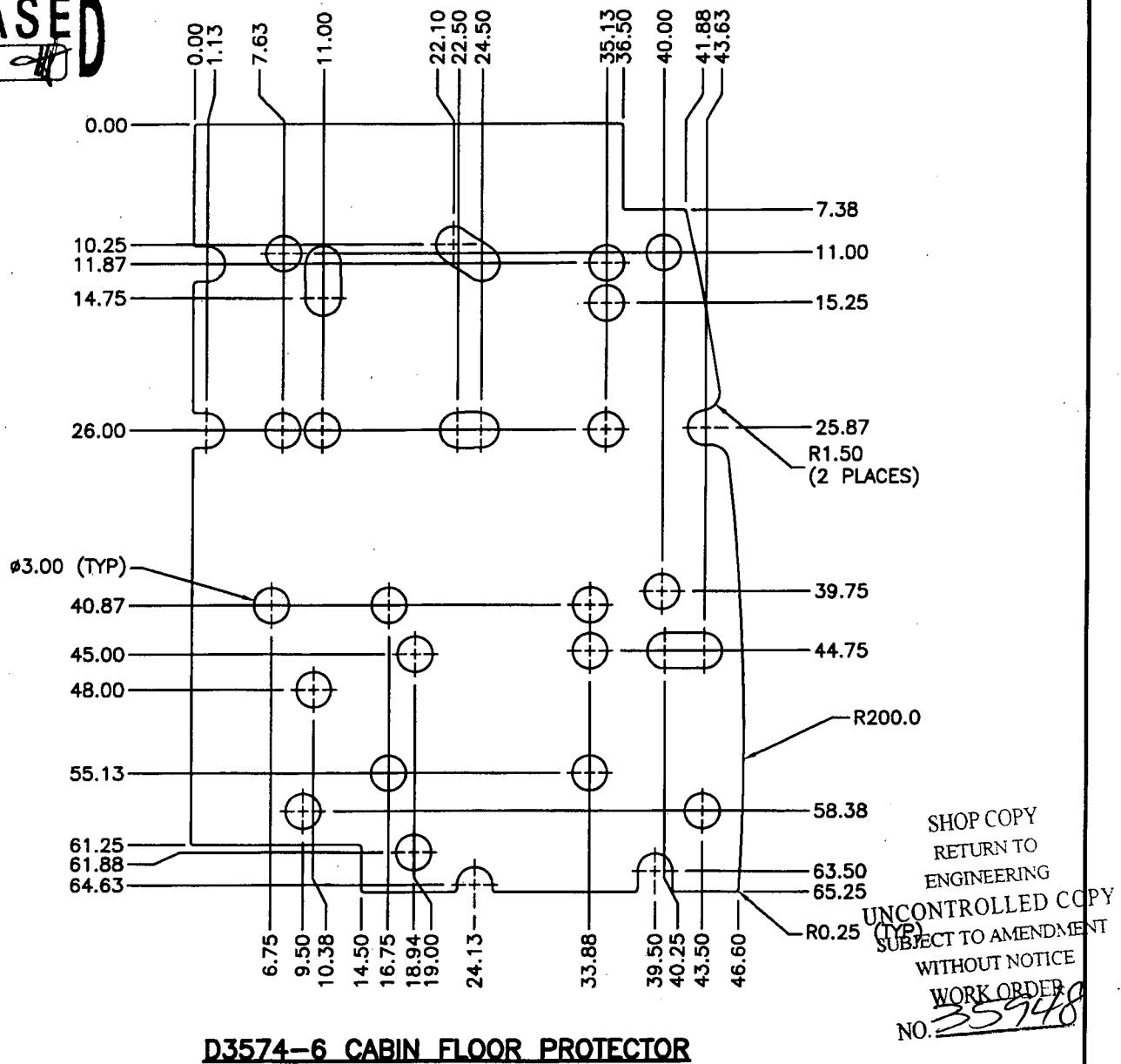
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14	

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07.06.27 

07.06.27 off



D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD

Work Order: 35948

Description: CABIN FLOOR PROTECTOR

Part Number: D3574-6

Inspection Dwg: 3574-6 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.13	+/- .030	1.13				
7.63	+/- .030	7.63				
11.06	+/- .030	11.06				
22.10	+/- .030	22.10				
22.50	+/- .030	22.50				
24.50	+/- .030	24.50				
35.13	+/- .030	35.13				
36.50	+/- .030	36.50				
40.00	+/- .030	40.00				
41.88	+/- .030	41.88				
43.63	+/- .030	43.63				
6.75	+/- .030	6.75				
9.50	+/- .030	9.50				
10.38	+/- .030	10.38				
14.50	+/- .030	14.50				
16.75	+/- .030	16.75				
18.94	+/- .030	18.94				
19.00	+/- .030	19.00				
24.13	+/- .030	24.13				
33.88	+/- .030	33.88				
39.50	+/- .030	39.50				
40.25	+/- .030	40.25				
43.50	+/- .030	43.50				
46.60	+/- .030	46.60				

Measured by: KB

Audited by: &

Prototype Approval: M

Date: 07-11-22

Date: 21/12/22

Date: 1/2

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

JL

Description: CABIN FLOOR PROTECTOR

Part Number: D3574-6

Inspection Dwg: D3574-6 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+.006 -.001	3.006	X			
7.38	+/- .030	7.38	X			
11.00	+/- .030	11.00	X			
15.25	+/- .030	15.25	X			
25.87	+/- .030	25.87	X			
39.75	+/- .030	39.75	X			
44.75	+/- .030	44.75	X			
58.38	+/- .030	58.38	X			
63.50	+/- .030	63.50	X			
65.25	+/- .030	65.25	X			
10.25	+/- .030	10.28	X			
11.87	+/- .030	11.87	X			
14.75	+/- .030	14.75	X			
26.00	+/- .030	26.00	X			
40.87	+/- .030	40.87	X			
45.00	+/- .030	45.00	X			
48.00	+/- .030	48.00	X			
55.13	+/- .030	55.13	X			
61.25	+/- .030	61.25	X			
61.88	+/- .030	61.88	X			
64.63	+/- .030	64.63	X			

Measured by:	B
Date:	07-11-22

Audited by:	G
Date:	7/11/22

Prototype Approval:	u/
Date:	7/1

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	